

Date: Friday, 06/02/2009 2:32:15 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR HANDLE KIT
Job Number : 45583	
Estimate Number : 10292	
P.O. Number :	Part Number : D412698013
This Issue : 06/02/2009 S.O. No. :	Drawing Number : IIN D412-698 REVE
Prsht Rev. : NC	Project Number : N/A
First Issue : 05/02/2009 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 43430	Material :
Written By :	Due Date : 28/02/2009 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev: C Removed Manufacturing 05-11-06 JLM Est Rev: D change to rev D ECN 1104 08-01-28 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/02/09



Comment: DOCUMENT CONTROL
 Photocopy bluefile and create labels per PPP D412-698-013CHG001

09/02/09

2.0	45583A	HANDLE
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Comment: Sub-Component-HANDLE

4 x D3203-1 Batch

45583A

SS 09/02/09 (x4)

3.0	D3220041	Doubler Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Doubler Assembly

3556-8B

SS 09/02/09 (x4)

4.0	D3220042	Doubler Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Doubler Assembly

33504 x2 B35568 c x2

SS 09/02/09 (x4)

5.0	D32203	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Doubler

40462

SS 09/02/09 (x4)

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Drawing Name: DOOR HANDLE KIT

Job Number: 45583

Part Number: D412698013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

AN960JD416L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416L Washer

M107008

SS 09/02/09 (X4)

8.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M109282

SS 09/02/09 (X4)

9.0

MS24694S98

Screw



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 MS24694-S98

Screw

M110363

SS 09/02/09 (X4)

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/02/11 (X4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-013

Location:

Box A

SS 09/02/11 (X4)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR HANDLE KIT

Job Number: 45583

Part Number: D412698013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/12
JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-12

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: **E**
Date: 08.05.01